

Date: Thursday, 5/10/2007 2:23:41 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARSHOE  
Job Number : 32269  
Estimate Number : 12734  
P.O. Number : *N/A*  
This Issue : 5/10/2007 S.O. No. : *N/A*  
Prsht Rev. : NC  
First Issue : *N/A* Type : SMALL /MED FAB  
Previous Run : *N/A*  
Written By :  
Checked & Approved By : *[Signature]* 07.05.10  
Comment : Est Rev: A New Issue 07-02-15 JLM

Part Number : D353525  
Drawing Number : D3535 UNDER REVIEW  
Project Number : N/A  
Drawing Revision : *AB* *pt* 07.05.10  
Material : *N/A*  
Due Date : 5/17/2007 Qty: 4 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet



Comment: Qty.: 0.5355 sf(s)/Unit Total : 2.1420 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: *M101873 (3) M103713 (4) SAD*

*07/05/14*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

*NOTE: CHECK Rev of DWG and Flat pattern*

*SAD 07/05/14*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD*

*07/05/14*

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*07.05.15 (4)*

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261 and DT8326

2-Form joggle on Punch as per Dwg D3535 using Jig DT8158 Identify as D3535-25

*mf 07-05-16*  
*mf 07-05-16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 2 Date: 07/05/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32269

Part Number: D353525

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/16 (4)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

07-05-17 (4)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/05/18 (4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/05/18 (4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/18 (4)

Job Completion

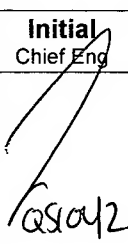


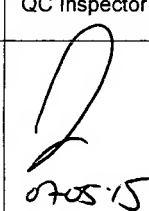


07.05.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/14	2.0	<del>wrong Re</del> Scrap one part wrong Revision	 QS1042	Scrap - destroy replace	SAN 07/05/14	 QS15	 QS1042	 070515

NOTE: Date & initial all entries

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

PORT HADLOCK, WA

DRAWN BY  
PH

**DRAWING NO.**

**CHECKED**

APPROVED

D3535

DATE \_\_\_\_\_

1

**TITLE**

07.04.17

2

WEARSHOE

1:10

A

06.10.25

NEW ISSUE



07.04.17

MOVE TAB. OUTBOARD, ADD AMS SPEC

57.04.24





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NO 32269

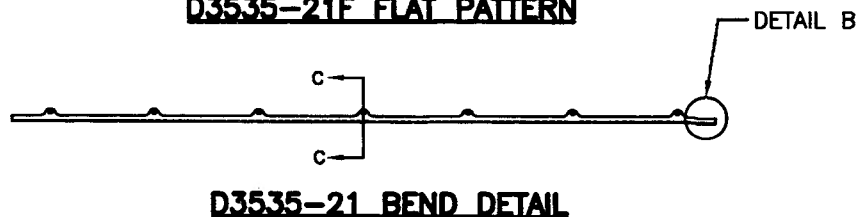
## NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEDX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



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CHECKED 	APPROVED 	DRAWING NO. <b>D3535</b>	SHEET 2 OF 7	
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>		SCALE <b>1:10</b>	



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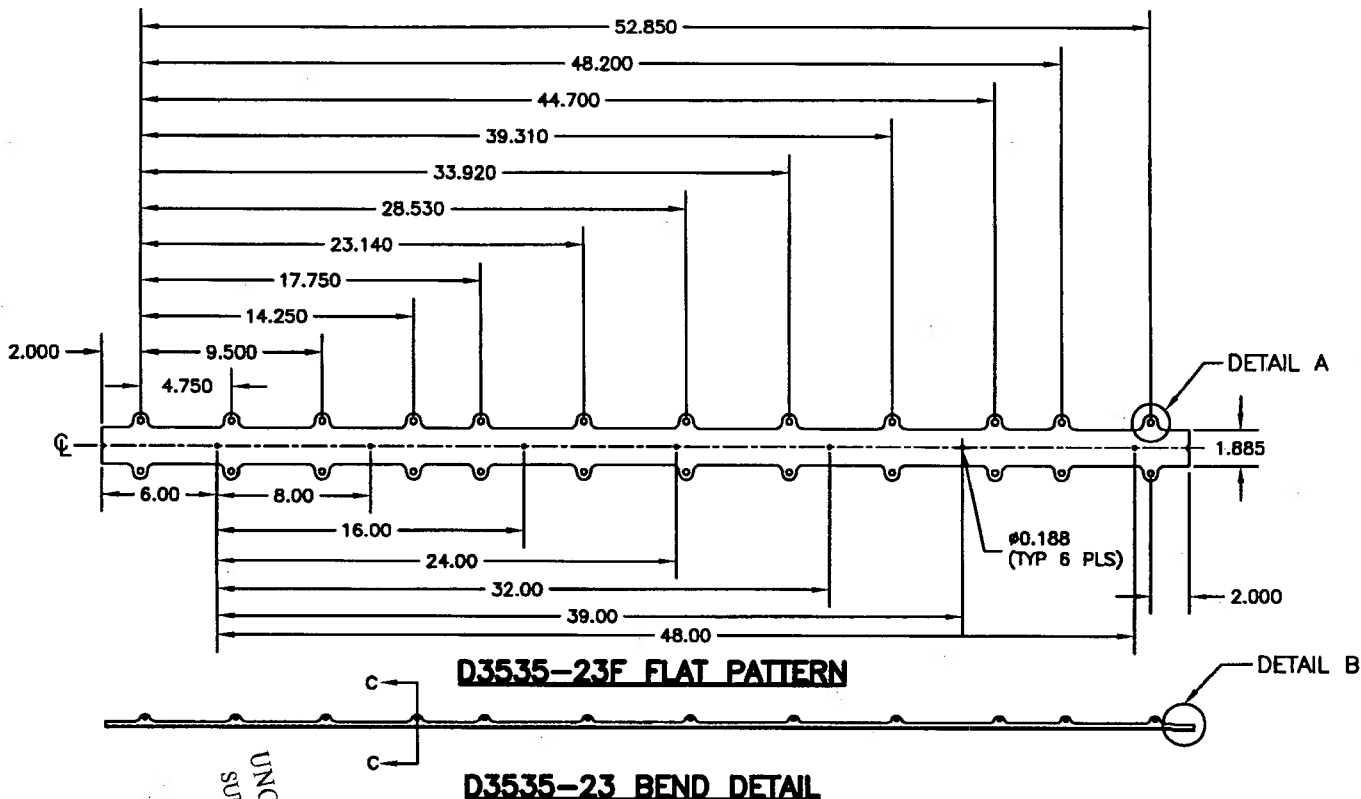
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		TITLE	WEARSHOE	SHEET 3 OF 7
		SCALE	1:10	

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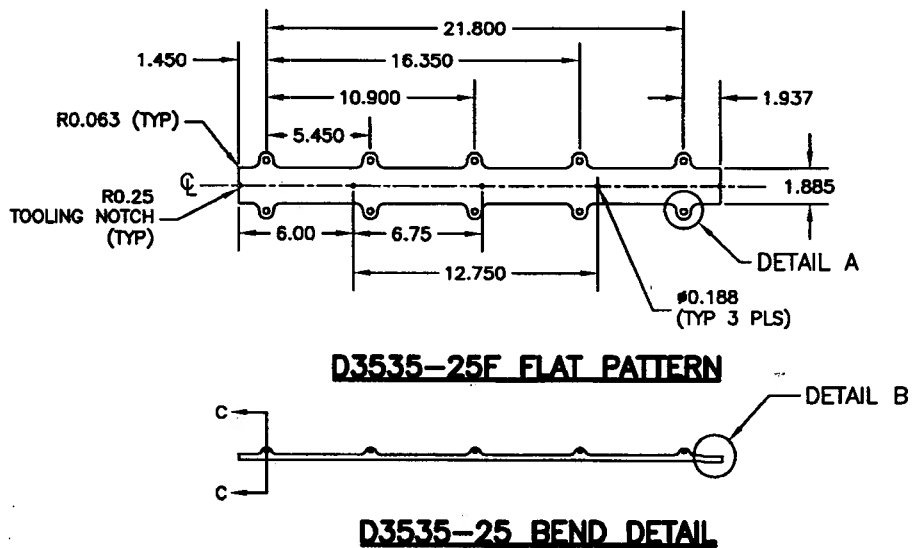
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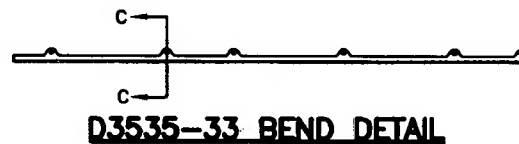
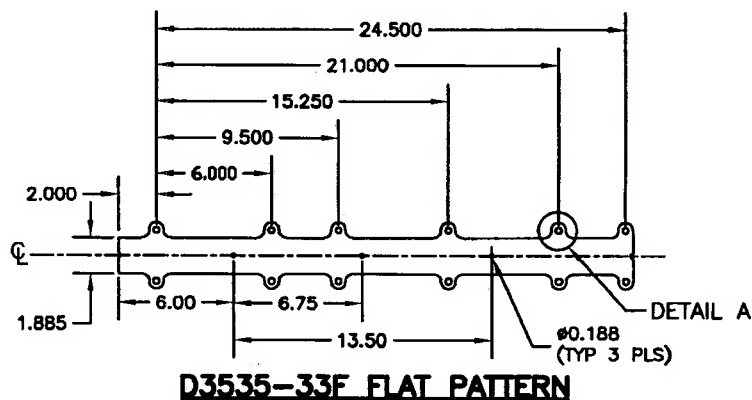
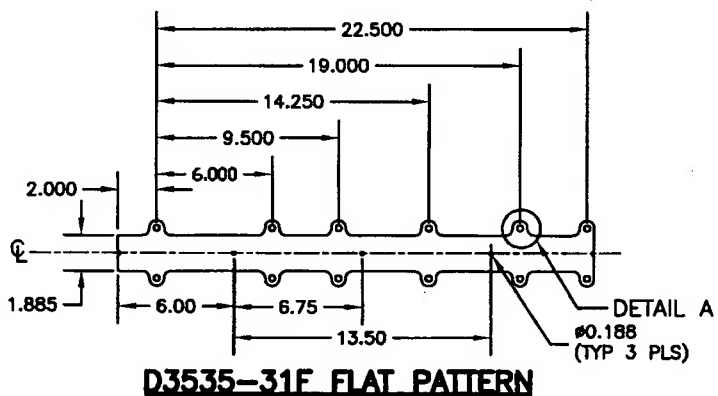
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DATE	07.04.17	TITLE	WEARSHOE	REV. B SHEET 4 OF 7
		SCALE	1:10	



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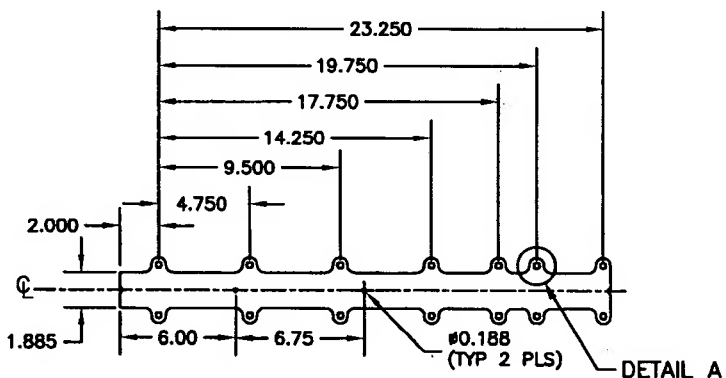


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DATE	07.04.17	DRAWING NO.	D3535	REV. B
TITLE	WEARSHOE	SHEET	5 OF 7	SCALE
				1:10



**D3535-35F FLAT PATTERN**

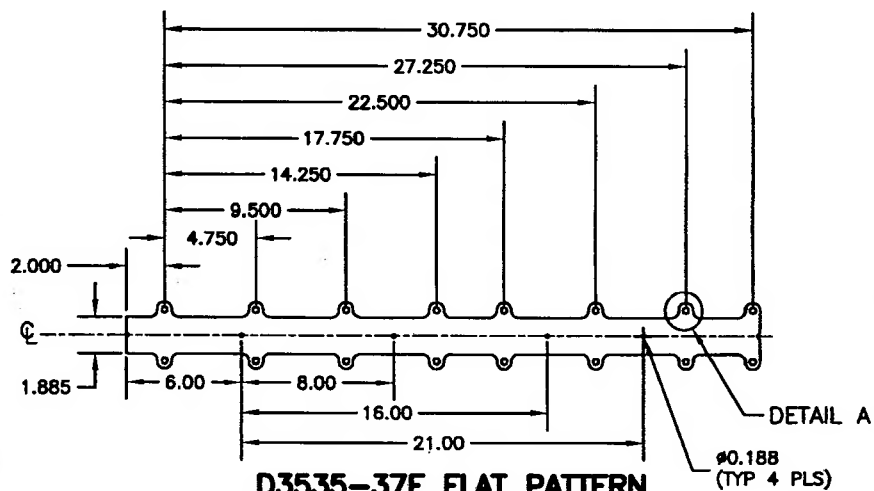


**D3535-35 BEND DETAIL**

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**D3535-37F FLAT PATTERN**

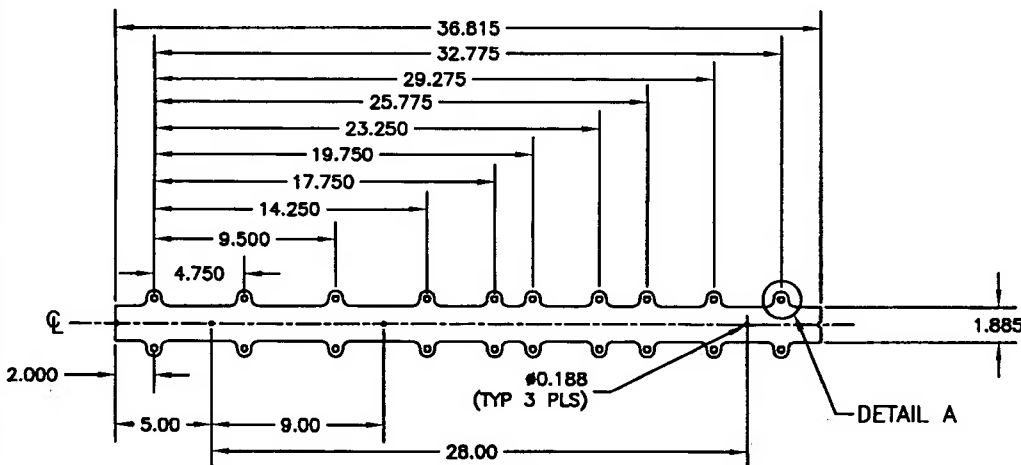


**D3535-37 BEND DETAIL**

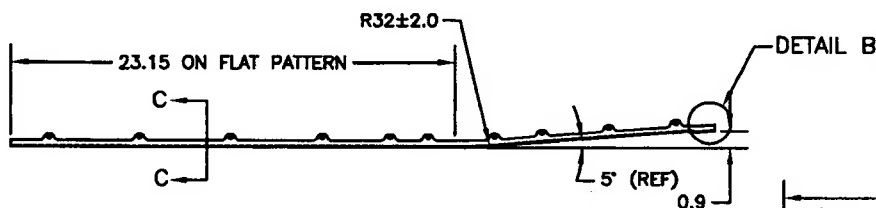
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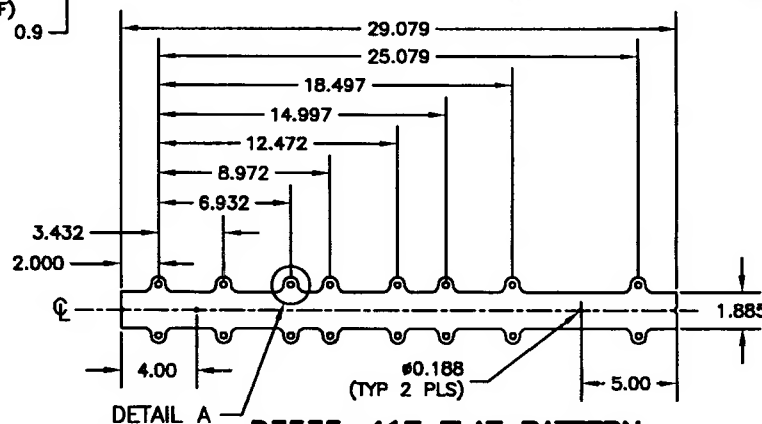
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	



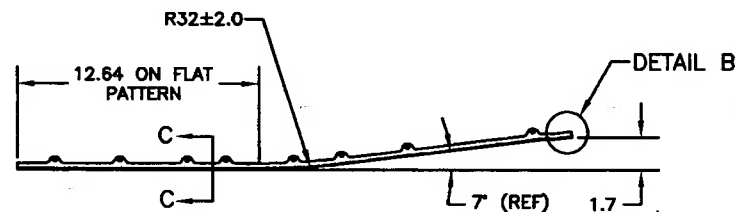
**D3535-39F FLAT PATTERN**



**D3535-39 BEND DETAIL**



**D3535-41F FLAT PATTERN**



**D3535-41 BEND DETAIL**

**NOTES**

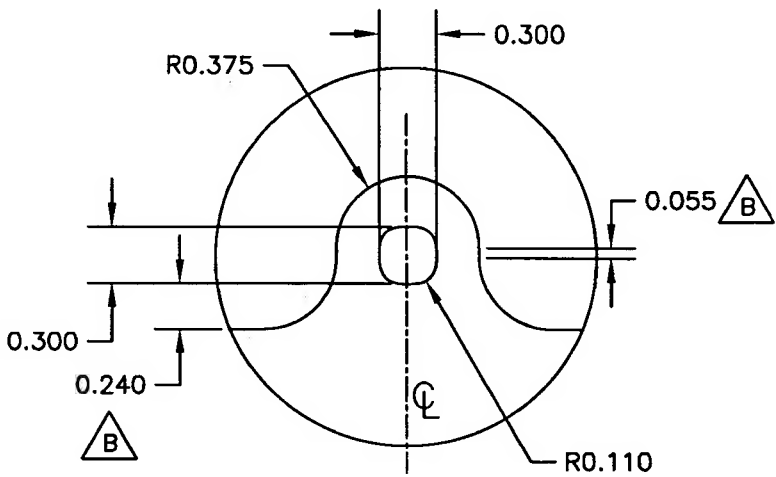
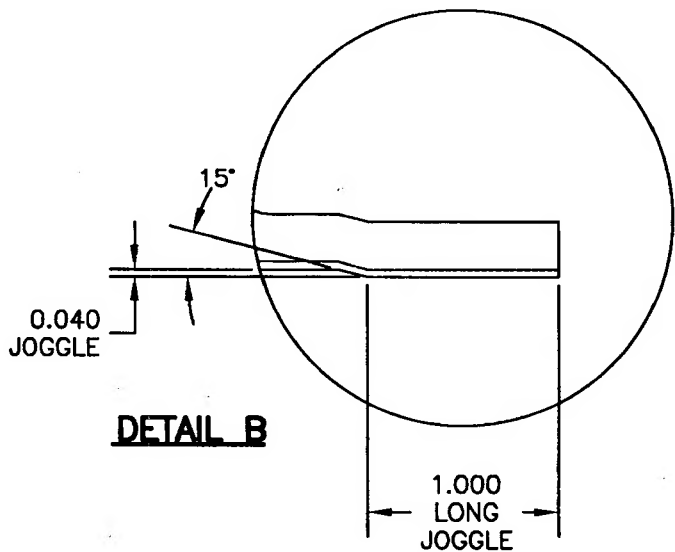
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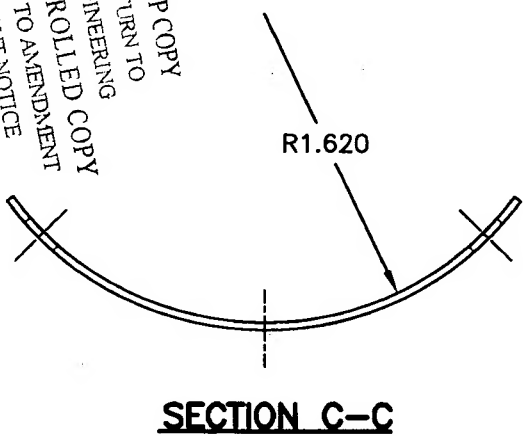


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DATE	07.04.17	TITLE	WEARSHOE	REV. B
				DRAWING NO. D3535
				SHEET 7 OF 7
				SCALE 1:1

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07.04.24 *[Signature]*



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DART AEROSPACE LTD		Work Order: 32269
Description: WEARSHOE		Part Number: D353525
Inspection Dwg: D3535 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 21.800	+/- 0.010	21.800	✓		M-T/Vern	
B 16.350	+/- 0.010	16.350	✓		M-T/Vern	
C 10.900	+/- 0.010	10.900	✓		M-T/Vern	
D 5.450	+/- 0.010	5.448	✓		Vern	
E 1.450	+/- 0.010	1.458	✓		height-gauge	
F 6.00	+/- 0.030	6.01	✓		height-gauge	
G 6.75	+/- 0.030	6.744	✓		height-gauge	
H 12.750	+/- 0.010	12.750	✓		M-T	
I 1.885	+/- 0.010	1.892	✓		Vern	
J 1.937	+/- 0.010	1.937	✓		M-T/height-gauge	
K 6.300	+/- 0.010	0.302	✓		Vern	
L 0.300	+/- 0.010	0.302	✓		Vern	
M 6.038	+/- 0.010	0.037	✓		Vern	
N 0.188	+ 0.005 - 0.003	0.191	✓		Vern	
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD	Audited by: [Signature]	Prototype Approval: N/A		
Date: 07/05/14	Date: 070515	Date: N/A 07.05-14		
Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

